

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018232**Date Inspected:** 20-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 007421

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Suspender Bracket. The weld designations reviewed are as follows:

1. SB018-100-0004, 007, 008
2. SB018-096-004, 007, 020

Ultrasonic Testing (UT) – NWIT Document No: 007424

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment. The weld designations reviewed are as follows:

1. SEG3019AP-001, 002, 003, 005
2. SEG3019AQ-024
3. SEG3011A-011

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Ultrasonic Testing (UT) – NWIT Document No: 007430

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment. The weld designations reviewed are as follows:

1. SEG3019AY-238, 239, 240
2. SEG3019AZ-228, 229, 230

Bay 16

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of welds joint BP3056-001-051 located on bottom plate of OBG Segment 14E. ZPMC Welder is identified as 2018888. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

Flux Core Arc Welding (FCAW) welding of welds joint BP3056-001-045 located on bottom plate of OBG Segment 14E. ZPMC Welder is identified as 066479. ZPMC Quality Control (QC) is identified as Mr. Wang Wei Ming. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

Flux Core Arc Welding (FCAW) welding of weld joint W5-SB1-061-106 and 108 located on OBG steel barrier. Welder is identified as 201879. ZPMC Quality Control (QC) is identified as Mr. Ma Qian Li. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

FCAW welding of weld joint W5-SB19-001-088, 089, 090, 091, 092, and 093 located on OBG steel barrier. Welder is identified as 218995. ZPMC Quality Control (QC) is identified as Mr. Ma Qian Li. The welding variables recorded by QC appeared to comply with the Applicable WPS -B-T-2132.

Visual Inspection after Blast

OBG Segment 12AW

This QA Inspector performed a preliminary random visual inspection on OBG Segment 12AW, after the grit blast of the interior bottom components of the deck planes, floor beams, bottom plates; side plates longitudinal Diaphragm and corner assemblies of this segment panel point PP111 to P112.5. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Vibin	Quality Assurance Inspector
<b>Reviewed By:</b>	Patel,Hiranch	QA Reviewer

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